



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)   |                             |                                 |                 |                           |                       |                          |
|----------|------|--|-----------------------------|---------------------------------|-----------------|---------------------------|-----------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                 | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|          |      |  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date  |                           |                       |                          |
| 07/08/04 | 2    | 1 piece scrap, the piece<br><del>are</del> are .030" off on the<br>"x" axis. the dimensions<br>.500" are .470" @ the<br>bushing hole location. | WJL<br>07/08/27             | scrap and replace               | owl<br>07/08/04 | JM                        | WJS<br>07/08/27       | J<br>07/08/24            |
|          |      |  |                             |                                 |                 |                           |                       |                          |
|          |      |  |                             |                                 |                 |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 7/10/2008 2:27:45 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 33669

Part Number: D29392

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SD 07.08.16

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL / FD

07/08/17 ⑩ P

7.0 POWDER COATING

POWDER COATING



M 105068

⑩

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL/M. 07-08-20

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



H8/22 SD

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

CJ 07/08/22 ⑩

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.08.23

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|  |              |             |
|--|--------------|-------------|
| DART AEROSPACE LTD                           | Work Order:  | 33669       |
| Description: 206 Saddle, Inboard, Right side | Part Number: | D2939-2     |
| Inspection Dwg: D2939 Rev. C                 |              | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |       | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
|               |       |       |                | 1                          | 2     | 3     | 4     |    |      |
| A             | 0.100 | 0.140 |                | 0.127                      | 0.128 | 0.128 | 0.124 |    |      |
| B             | 0.100 | 0.140 |                | 0.136                      | 0.130 | 0.130 | 0.127 |    |      |
| C             | 0.100 | 0.140 |                | 0.114                      | 0.116 | 0.188 | 0.115 |    |      |
| D             | 0.210 | 0.230 |                | 0.224                      | 0.223 | 0.224 | 0.224 |    |      |
| E             | 1.245 | 1.255 |                | 1.249                      | 1.249 | 1.250 | 1.249 |    |      |
| F             | 1.245 | 1.255 |                | 1.249                      | 1.249 | 1.249 | 1.249 |    |      |
| G             | 2.495 | 2.505 |                | 2.499                      | 2.499 | 2.506 | 2.506 |    |      |
| H             | 0.510 | 0.515 |                | 0.510                      | 0.510 | 0.510 | 0.510 |    |      |
| I             | 1.572 | 1.582 |                | 1.578                      | 1.576 | 1.576 | 1.576 |    |      |
| J             | 2.495 | 2.505 |                | 2.499                      | 2.499 | 2.499 | 2.499 |    |      |
| K             | 0.257 | 0.262 |                | 0.258                      | 0.258 | 0.258 | 0.258 |    |      |
| L             | 0.312 | 0.317 |                | 0.314                      | 0.314 | 0.314 | 0.314 |    |      |
| M             | 0.235 | 0.240 |                | 0.238                      | 0.238 | 0.239 | 0.238 |    |      |
| N             | 0.100 | 0.140 |                | 0.121                      | 0.121 | 0.122 | 0.121 |    |      |
| O             | 0.540 | 0.560 |                | 0.550                      | 0.550 | 0.550 | 0.550 |    |      |
| P             | 0.490 | 0.510 |                | 0.503                      | 0.502 | 0.502 | 0.501 |    |      |
| Q             | 3.715 | 3.725 |                | 3.717                      | 3.717 | 3.717 | 3.717 |    |      |
| R             | 2.720 | 2.760 |                | 2.746                      | 2.746 | 2.746 | 2.746 |    |      |
| S             | 0.240 | 0.270 |                | 0.253                      | 0.256 | 0.256 | 0.255 |    |      |
| T             | 0.100 | 0.180 |                | 0.134                      | 0.136 | 0.138 | 0.140 |    |      |
| U             | 1.625 | 1.635 |                | 1.628                      | 1.628 | 1.628 | 1.628 |    |      |
| V             | 1.362 | 1.372 |                | 1.366                      | 1.366 | 1.366 | 1.366 |    |      |
| W             | 0.316 | 0.321 |                | 0.320                      | 0.320 | 0.320 | 0.320 |    |      |
| X             | 1.250 | 1.270 |                | 1.264                      | 1.262 | 1.260 | 1.261 |    |      |
| Y             | 1.565 | 1.585 | DT8695 A/B     | 1.577                      | 1.574 | 1.574 | 1.573 |    |      |
| Z             | 0.178 | 0.198 |                | 0.188                      | 0.188 | 0.188 | 0.188 |    |      |
| AA            |       |       |                |                            |       |       |       |    |      |
| AB            |       |       |                |                            |       |       |       |    |      |
| AC            |       |       |                |                            |       |       |       |    |      |
| AD            |       |       |                |                            |       |       |       |    |      |
| AE            |       |       |                |                            |       |       |       |    |      |
| AF            |       |       |                |                            |       |       |       |    |      |
| AG            |       |       |                |                            |       |       |       |    |      |
| AH            |       |       |                |                            |       |       |       |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|              |            |             |           |
|--------------|------------|-------------|-----------|
| Measured by: | <i>DMR</i> | Audited by: | <i>SA</i> |
| Date:        | 07/08/16   | Date:       | 07.08.16  |

| Rev | Date     | Change   | Revised by       | Approved  |
|-----|----------|--|------------------|-----------|
| A   |          | New Issue  | RF               |           |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF            |           |
| C   | 07.03.21 | Revised per drawing revision C                                 | KJ/JLM <i>JL</i> | <i>JL</i> |

|  |              |             |
|--|--------------|-------------|
| DART AEROSPACE LTD                           | Work Order:  | 33669       |
| Description: 206 Saddle, Inboard, Right side | Part Number: | D2939-2     |
| Inspection Dwg: D2939 Rev. C                 |              | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3     | 4     | By | Date |
| A             | 0.100 | 0.140 |                | 0.126                      | 0.127 | 0.127 | 0.127 |    |      |
| B             | 0.100 | 0.140 |                | 0.128                      | 0.127 | 0.128 | 0.128 |    |      |
| C             | 0.100 | 0.140 |                | 0.116                      | 0.117 | 0.114 | 0.117 |    |      |
| D             | 0.210 | 0.230 |                | 0.224                      | 0.224 | 0.224 | 0.224 |    |      |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.249 | 1.249 |    |      |
| F             | 1.245 | 1.255 |                | 1.249                      | 1.250 | 1.249 | 1.249 |    |      |
| G             | 2.495 | 2.505 |                | 2.499                      | 2.500 | 2.500 | 2.500 |    |      |
| H             | 0.510 | 0.515 |                | 0.510                      | 0.510 | 0.510 | 0.510 |    |      |
| I             | 1.572 | 1.582 |                | 1.576                      | 1.576 | 1.576 | 1.577 |    |      |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| K             | 0.257 | 0.262 |                | 0.258                      | 0.258 | 0.258 | 0.258 |    |      |
| L             | 0.312 | 0.317 |                | 0.314                      | 0.314 | 0.314 | 0.314 |    |      |
| M             | 0.235 | 0.240 |                | 0.238                      | 0.238 | 0.238 | 0.238 |    |      |
| N             | 0.100 | 0.140 |                | 0.121                      | 0.121 | 0.121 | 0.121 |    |      |
| O             | 0.540 | 0.560 |                | 0.556                      | 0.551 | 0.550 | 0.551 |    |      |
| P             | 0.490 | 0.510 |                | 0.502                      | 0.503 | 0.502 | 0.503 |    |      |
| Q             | 3.715 | 3.725 |                | 3.718                      | 3.718 | 3.718 | 3.718 |    |      |
| R             | 2.720 | 2.760 |                | 2.746                      | 2.746 | 2.746 | 2.746 |    |      |
| S             | 0.240 | 0.270 |                | 0.256                      | 0.255 | 0.256 | 0.256 |    |      |
| T             | 0.100 | 0.180 |                | 0.140                      | 0.140 | 0.140 | 0.140 |    |      |
| U             | 1.625 | 1.635 |                | 1.628                      | 1.628 | 1.628 | 1.628 |    |      |
| V             | 1.362 | 1.372 |                | 1.366                      | 1.366 | 1.366 | 1.367 |    |      |
| W             | 0.316 | 0.321 |                | 0.320                      | 0.320 | 0.320 | 0.320 |    |      |
| X             | 1.250 | 1.270 |                | 1.261                      | 1.261 | 1.260 | 1.260 |    |      |
| Y             | 1.565 | 1.585 | DT8695 A/B     | 1.574                      | 1.573 | 1.574 | 1.573 |    |      |
| Z             | 0.178 | 0.198 |                | 0.188                      | 0.188 | 0.188 | 0.188 |    |      |
| AA            |       |       |                |                            |       |       |       |    |      |
| AB            |       |       |                |                            |       |       |       |    |      |
| AC            |       |       |                |                            |       |       |       |    |      |
| AD            |       |       |                |                            |       |       |       |    |      |
| AE            |       |       |                |                            |       |       |       |    |      |
| AF            |       |       |                |                            |       |       |       |    |      |
| AG            |       |       |                |                            |       |       |       |    |      |
| AH            |       |       |                |                            |       |       |       |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|              |            |             |           |
|--------------|------------|-------------|-----------|
| Measured by: | <i>cmk</i> | Audited by: | <i>SD</i> |
| Date:        | 07/08/05   | Date:       | 07.08.16  |

| Rev | Date     | Change   | Revised by       | Approved   |
|-----|----------|--|------------------|------------|
| A   |          | New Issue  | RF               |            |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF            |            |
| C   | 07.03.21 | Revised per drawing revision C                                 | KJ/JLM <i>JK</i> | <i>SPM</i> |

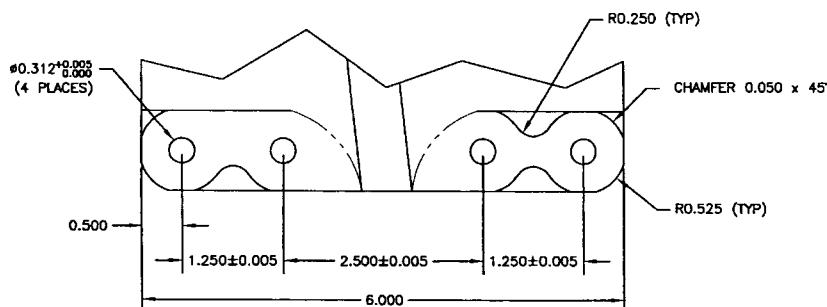
|  |              |             |
|--|--------------|-------------|
| DART AEROSPACE LTD                           | Work Order:  | 33669       |
| Description: 206 Saddle, Inboard, Right side | Part Number: | D2939-2     |
| Inspection Dwg: D2939 Rev. C                 |              | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

|               |       |       |                | Recorded Actual Dimensions |       |   |   |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|---|---|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3 | 4 | By | Date |
| A             | 0.100 | 0.140 |                | 0.126                      | 0.126 |   |   |    |      |
| B             | 0.100 | 0.140 |                | 0.126                      | 0.126 |   |   |    |      |
| C             | 0.100 | 0.140 |                | 0.116                      | 0.117 |   |   |    |      |
| D             | 0.210 | 0.230 |                | 0.224                      | 0.224 |   |   |    |      |
| E             | 1.245 | 1.255 |                | 1.249                      | 1.249 |   |   |    |      |
| F             | 1.245 | 1.255 |                | 1.249                      | 1.249 |   |   |    |      |
| G             | 2.495 | 2.505 |                | 2.506                      | 2.506 |   |   |    |      |
| H             | 0.510 | 0.515 |                | 0.570                      | 0.570 |   |   |    |      |
| I             | 1.572 | 1.582 |                | 1.576                      | 1.576 |   |   |    |      |
| J             | 2.495 | 2.505 |                | 2.506                      | 2.506 |   |   |    |      |
| K             | 0.257 | 0.262 |                | 0.258                      | 0.258 |   |   |    |      |
| L             | 0.312 | 0.317 |                | 0.314                      | 0.314 |   |   |    |      |
| M             | 0.235 | 0.240 |                | 0.238                      | 0.238 |   |   |    |      |
| N             | 0.100 | 0.140 |                | 0.121                      | 0.121 |   |   |    |      |
| O             | 0.540 | 0.560 |                | 0.551                      | 0.551 |   |   |    |      |
| P             | 0.490 | 0.510 |                | 0.503                      | 0.501 |   |   |    |      |
| Q             | 3.715 | 3.725 |                | 3.718                      | 3.718 |   |   |    |      |
| R             | 2.720 | 2.760 |                | 2.740                      | 2.746 |   |   |    |      |
| S             | 0.240 | 0.270 |                | 0.256                      | 0.256 |   |   |    |      |
| T             | 0.100 | 0.180 |                | 0.135                      | 0.135 |   |   |    |      |
| U             | 1.625 | 1.635 |                | 1.628                      | 1.628 |   |   |    |      |
| V             | 1.362 | 1.372 |                | 1.366                      | 1.366 |   |   |    |      |
| W             | 0.316 | 0.321 |                | 0.320                      | 0.320 |   |   |    |      |
| X             | 1.250 | 1.270 |                | 1.261                      | 1.260 |   |   |    |      |
| Y             | 1.565 | 1.585 | DT8695 A/B     | 1.573                      | 1.573 |   |   |    |      |
| Z             | 0.178 | 0.198 |                | 0.188                      | 0.188 |   |   |    |      |
| AA            |       |       |                |                            |       |   |   |    |      |
| AB            |       |       |                |                            |       |   |   |    |      |
| AC            |       |       |                |                            |       |   |   |    |      |
| AD            |       |       |                |                            |       |   |   |    |      |
| AE            |       |       |                |                            |       |   |   |    |      |
| AF            |       |       |                |                            |       |   |   |    |      |
| AG            |       |       |                |                            |       |   |   |    |      |
| AH            |       |       |                |                            |       |   |   |    |      |
| Accept/Reject |       |       |                |                            |       |   |   |    |      |

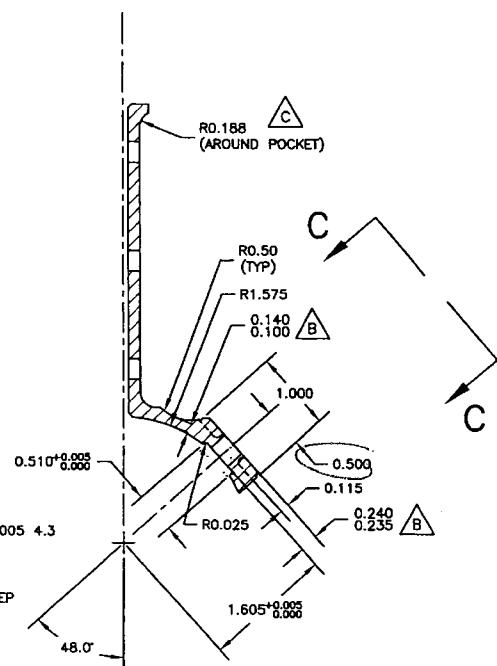
|              |                 |             |                 |
|--------------|-----------------|-------------|-----------------|
| Measured by: | <i>JML</i>      | Audited by: | <i>01.08.16</i> |
| Date:        | <i>07/08/05</i> | Date:       | <i>SA</i>       |

| Rev | Date     | Change   | Revised by               | Approved           |
|-----|----------|--|--------------------------|--------------------|
| A   |          | New Issue  | RF                       |                    |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF                    |                    |
| C   | 07.03.21 | Revised per drawing revision C                                 | KJ/JLM <i>[initials]</i> | <i>[Signature]</i> |



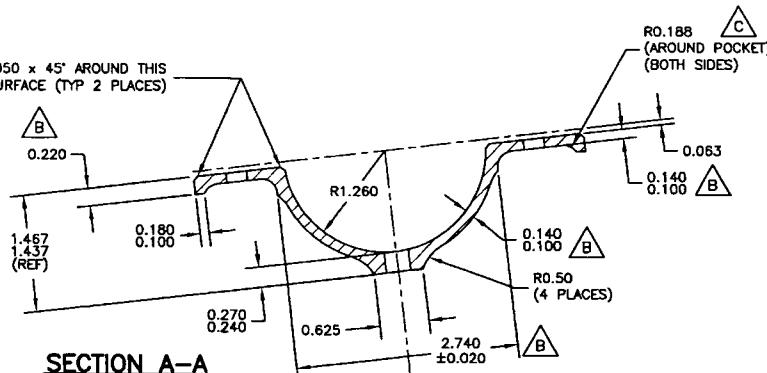
VIEW C-C

D2939-1 LH SADDLE (SHOWN)  
D2939-2 RH SADDLE (OPPOSITE)

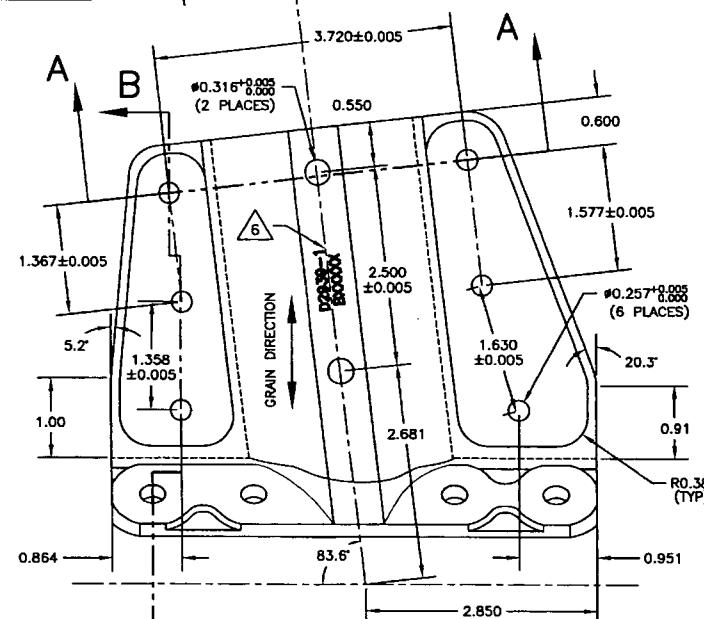


SECTION B-B

CHAMFER 0.050 x 45° AROUND THE SURFACE (TYP 2 PLACES)



SECTION A-A



8

|  |   |  |
|--|---|--|
| C  | 06.11.09  | RO.188 WAS RO.30 TO RO.25                            |
| B  | 00.05.29  | CHANGED DEOMETRY AND MATERIAL.                       |
| A  | 99.11.12  | NEW ISSUE  |
| DESIGN<br>  | DRAWN BY<br> | <b>DART</b> DART AEROSPACE USA, INC.<br>BELLEVUE, WA |
| CHECKED<br> | APPROVED<br> | DRAWING NO. D2939 REV. C<br>SHEET 1 OF 1             |
| DATE<br>06.11.09   | TITLE<br>SADDLE INSIDE  | SCALE<br>2:3   |

01-02-12 ~~off~~

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NO. 33669

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